Hardinge

Hardinge CNC Lathe Small

1-Turn as per Folio FA626 & Dwg D3493 2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Quality Control

120

QC8- Inspect parts - second check

Memo

0.00

QC

Memo

Quality Control

W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHA	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										1
	:									
Part No	:	PAR #:	Fault Cate	egory:	NCR: `	Yes N	10 DQ .	A :	_ Date: _	
	R	esolution:	Disposition	on:	QA: N/	C Clo	sed:		Date: _	
NCR:			WORK ORE	ER NON-CONFORM	MANCE (I	ICR))	-		
DATE	STEP	Description of NC		ection B	Verific		cation Approval		Approvai	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Sect	ion C	Chief Eng	QC Inspector
					<u> </u>					
l i										
	<u> </u>						 			
				•						

Work Order ID 61672

Tuesday, August 31, 2010 10:45:31 AM



Page 2

Item ID:

D3493-1

Accept



Setup Start

Stop

Revision ID:

Start Date:

Washer Item Name:

Required Date: 9/7/2010

8/31/2010

Start Qty: 40.00 Req'd Qty: 40.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Qty_



Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 062

Memo

Memo

0.00 0.00 Tool ID

Tool # Plan Code

Accept Qty

Reject Reject

Insp. Number Stamp

0.00



Quality Control

140

QC21- Final Inspection - Work Order Release

0.00

10 log b8 de

W/O:			WC	RK ORDER CH	ANGES					· · · · · ·
DATE	STEP	PRO	OCEDURE CHA			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					· · ·				Frod Wgi	
Part No		PAR #:	Fault Cate	gory:	NC	R: Yes I	No DQ	A:	Date:	
		esolution:								
NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification			1 Approval	Approvai
DATE	SIEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign & Date		on C	Chief Eng	QC Inspector

Picklist Print

Tuesday, August 31, 2010 10:45:36 AM

Work Order ID: 61672

Parent Item: D3493-1

Parent Item Name: Washer



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev: A New Issue 06-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			100	f	76.7300	0.0291	1.225263	10)0	î/2	7

304 round bar 1.00

Location		Loc Oty	Loc Code
MAT029		76.73	
	109508	9.8	
	109541	18.26	
	113457	48.67	

1.2 St

Dart Ae	rospace	Ltd								
W/O:	-		WC	RK ORDER CHAN	IGES					······································
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:					
		-								
Part No	:	PAR #:	Fault Cate	gory:	NCF	R: Yes I	No DQ	A:	Date: _	
	R	esolution:	Disposition	n:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORDI	R NON-CONFOR	MANCE	(NCR)	•		
DATE	CTED	Description of NC			Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descriptio	n	Sign & Date		ion C	Chief Eng	QC Inspector
					Transfer of					Í

DART AEROSPACE LTD	Work Order:	41412
Description: Washer	Part Number:	D3493-1
Inspection Dwg: D3493 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

)	× F	First Article	Prototype	е
		Antoni		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.192	+0.000/-0.005	150			Vela	31/7
Ø1.000	+/-0.010	.998			~	
Ø0.958 x 100°	+/-0.010	d) SLEXIOS	'/			
Ø0.516	+0.008/-0.001	.520				
				•		
			·			

		,		
Measured by:	Audited by:	ant	Prototype Approval:	N/A
Date: 10/08/27	Date:	10/09/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM	
В	06.11.22	Ø0.516 dimension removed	KJ/JLM 1.A	
С	08.04.30	Dimensions updated	KJ/DD 🛪	

W/O:			W	ORK ORDER CHANGE	ES		***	
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Prod Wigi	
Dort No.	_				NCD: Vac A	lo DOA:	Date	
Part No		PAR #:						
	R	esolution:			1.000		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE STEP		Description of NC	Description of NC Corrective Action			Verification		Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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						-		
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DESIGN	PH	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V		INC.
CHECKE	M G	APPROVED A	DRAWING NO.			REV. A
	-111	111	D3493		SH	EET 1 OF 1
DATE	·		TITLE			SCALE
06.0	1.04		WASHER			1:1
 Α		06.01.04	NEW ISSU	JE		

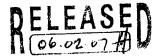
SHOP COPY RETURNITO

ENGINELRING UNCONTROLLED COMY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK OR DER NO. 4/472 Bf10-8-3/ $0.192^{+0.000}_{-0.005}$ Ø1.000 C'SINK -Ø0.958X100° Ø0.516

D3493-1 WASHER

D3493-1 WASHER

- MATERIAL: AISI 304/316 STAINLESS STEEL Ø1.000 ROUND BAR (REF DART MATERIAL SPEC M304R1.000)
- ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES 0.005 TO 0.010 MAX



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W/O:			WO	RK ORDER CHANG	SES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-								
							_		
٠									
Part No					CR: Yes No DQA: Date:				
Resolution:			Disposition: C		QA: N/C CI	.: N/C Closed:			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	1)			
DATE	STEP	Description of NC Section A			tion B	Verification		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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						4.			
									1